

# Work Order ID 81383

Wednesday, March 14, 2012 10:29:21 AM

**\*81383\***

*April 2nd*

Page 1

Item ID: D3914-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 3/14/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 3/30/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: mc Date: 12-03-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 118366 0.00  
 Large Fab

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

\*\*\*Visual inspect before welding mesh\*\*\*

3- tack weld mesh on basket as per dwg D3914

\*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

*PL 12-03-23*

*1x*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo

0.00

*BE*  
*12-03-23*

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*81383\***

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Item ID: D3914-041

Accept

**\*N9000040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop

**\*NS2\***

Start Date: 3/14/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time: 11:35

Oven Temperature: 320°F

Finish Time: 12:05

M117338

140

Wing Walk as per dwg QSI005 4.4 Batch 120959 0.00

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label\*\*\*

1 8 (2P) 12/03/27

1 BL 12-3-27

W/O:		WORK ORDER CHANGES					
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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>D4030-041</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

81373

1 12-3-28

12/3/29 AD

020328

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, March 14, 2012 10:29:21 AM

Page 1

Work Order ID: 81383

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	29.0000	2	2		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		29							
				69739		1							
				70766		2							
				77045		1							
				77523		25							
D3914-1 Rib		Manufactured	No			100	Each	0.0000	2	2		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				WA006		-2							
D3914-7 Rib		Manufactured	No			100	Each	2.0000	2	2		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		2							
				80164		2							
D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	18.0000	3	3		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		18							
				78495		18							
D4018-5 Rib		Manufactured	No			100	Each	7.0000	9	9		Pl 12.03.22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		7							
				80597		7							

380898 → ⑤

381208 → ⑤

378041 → ⑨

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 2

Work Order ID: 81383

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D4020-5 Manufactured No 100 Each 1.0000  
Mesh (350 Basket Long, Lid)

Location	Loc Qty	Loc Code
WA	1	
78698	1	

1 1 *PL12-03-22*

*B81180 → ①*

D4021-3 Manufactured No 100 Each 3.0000  
Data Plate

Location	Loc Qty	Loc Code
WA005	3	
75460	3	

1 1 *PL12-03-22*

*①* *PL12-03-22*

*B81701 → ①*

D4035-041 Manufactured No 100 Each 3.0000  
Lid Rib Assembly, Fwd (350 Basket)

Location	Loc Qty	Loc Code
WA006	3	
74642	3	

1 1 *PL12-03-22*

*B81201 → ①*

D4035-043 Manufactured No 100 Each 1.0000  
Lid Rib Assembly, Aft (350 Basket)

Location	Loc Qty	Loc Code
WA006	1	
76545	1	

1 1 *PL12-03-22*

D2728-3 Manufactured No 140 Each 0.0000  
Dart Logo label

*115050.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.17  
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ABS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	LONG BASKET LID ASSY (350)	NTS
DE APPR.	SC	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

81383

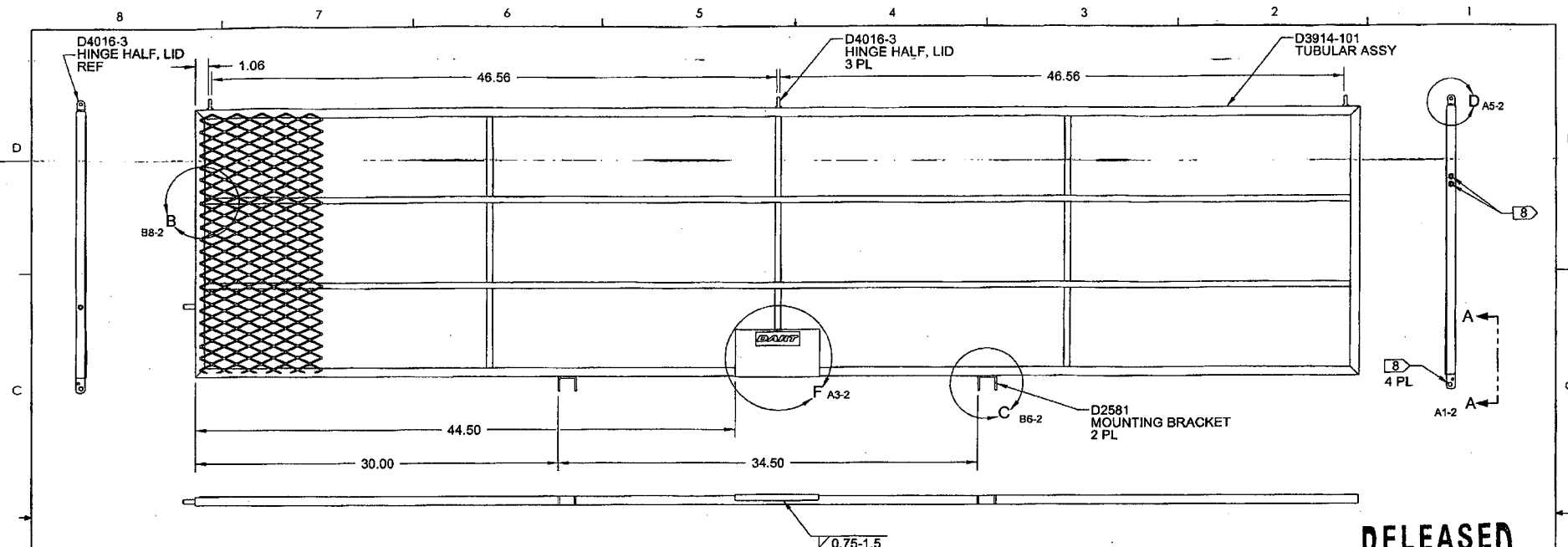
**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

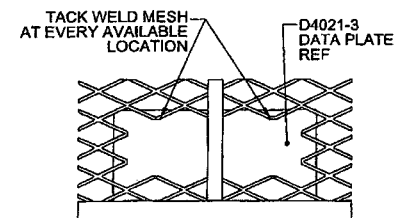
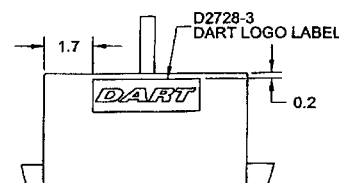
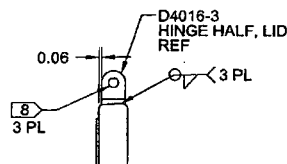
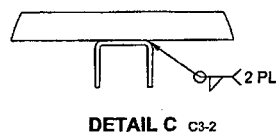
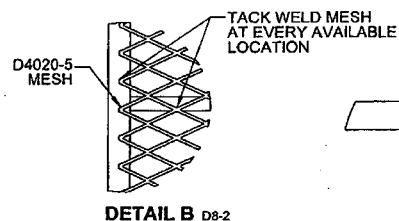
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.12 UP



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

#81383

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	EC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EC	DRAWING NO.	REV. B
MFG. APPR.	EC	<b>D3914</b>	SHEET 2 OF 4
APPROVED	EC	TITLE	SCALE
DE APPR.	EC	<b>LONG BASKET LID ASSY (350)</b>	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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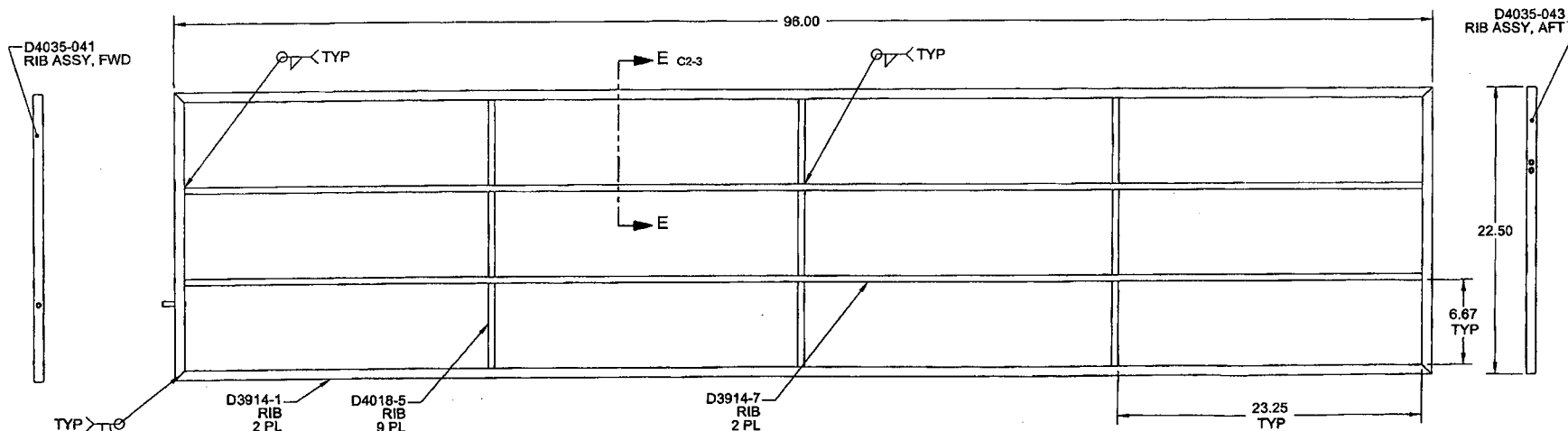
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



RELEASED  
10-08-12 97

8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

# 81383

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PC	DRAWING NO. D3914	REV. B
CHECKED	W	SHEET 3 OF 4	
MFG. APPR.	W	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
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DE APPR.	W		
DATE	10.08.05		

# Dart Aerospace Ltd

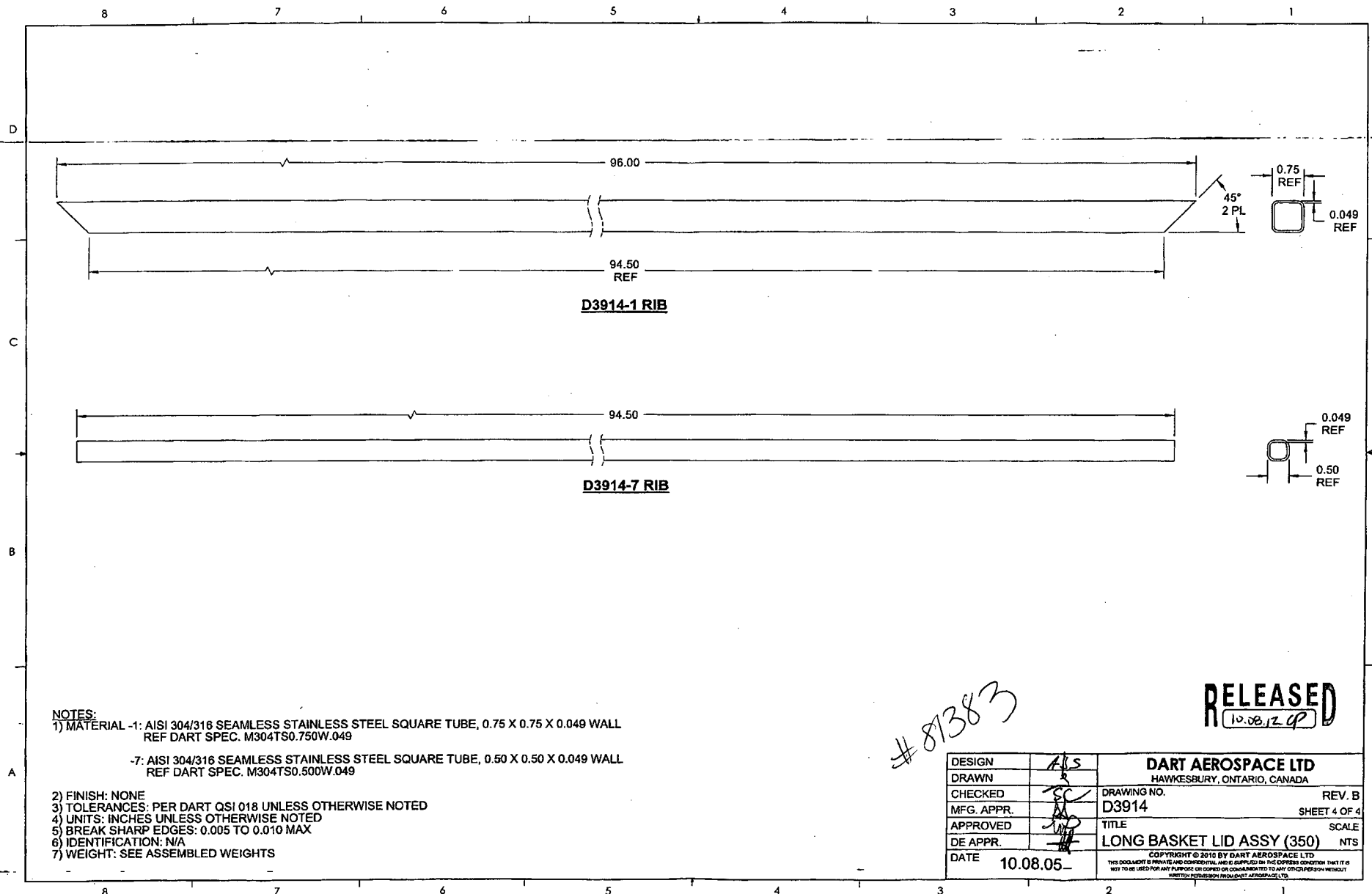
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